

Work Order ID 62710

Wednesday, October 06, 2010 3:39:12 PM



Page 1

Item ID: D4171-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 10/6/2010 Start Qty: 10.00

18.0



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10/06/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4171	A								

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg & Folio FA963
2-Deburr

10-10-13

18

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-10-13

18

140

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10/10/14

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 10/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: 135

0.00



Packaging

Memo

0.00

Packaging

[Signature] 10/10/18 (18)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 *[Signature]*
MF
10-10-18

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:39:16 PM

Page 1

Work Order ID: 62710

Parent Item: D4171-1

Parent Item Name: Bushing



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000 		Purchased	No			100	f	28.0560	0.08	0.842105		10.10.13	
303 Round Bar 1.00													

Location

Loc Qty

Loc Code

MAT

24

115774

24

MAT028

4.056

113325

4.056

1.365

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62710
Description: BUSHING		Part Number: 84171-1
Inspection Dwg: D4171 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article

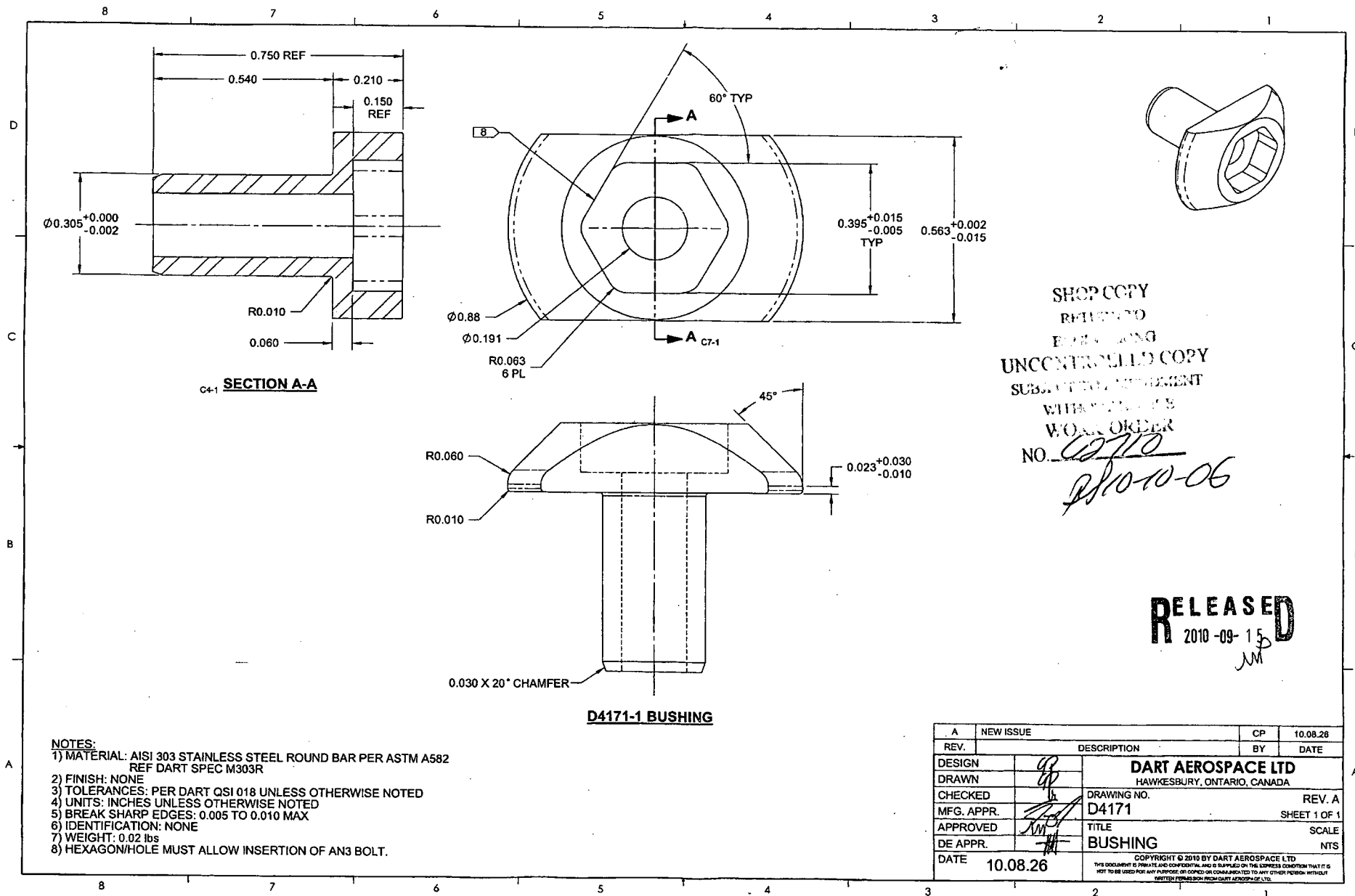


Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.750	+/- .010	.751	✓		Vernier	check all use
.540	+/- .010	.540	✓		specified.	
.210	+/- .010	.211	✓			
.150	+/- .010	.152	✓			
.305	10.0 - .002	.304	✓			
R.010	+/- .010	R.005	✓		Red gage	
.060	+/-	.060	✓			
.395	1.015 - 0.0	.396	✓			
.563	+ .002 - .015	.558	✓			
.88	+/- .03	.88	✓			
.1910	+ .005 - .001	.196	✓			
R.063	+/- .010	.063	✓		Red gage	
R.060	+/- .010	.060	✓		Red gage	
45°	+/- 1/2°	45°	✓			
.023	+ .03 - .010	.023	✓			
.03-20	+/- .030	.028	✓			

Measured by: <i>RL</i>	Audited by: <i>ant</i>	Prototype Approval:	N/A
Date: 10-10-14	Date: 10/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
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